



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1913

Job Sheet 181389



Part No: 647.1913

Job Qty: 45 ea

Part Name: Tee



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEETS 1,2,3,5 IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	45 Ea	9/10/18	9/10/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	45 pcs	9/10/18	9/10/18	0.00	2.25	Bandsaw1		
110	CNC Vertical Machining	45 pcs	9/10/18	9/10/18	0.00	32.14	HAAS1-1		
120	QC	45 pcs	9/10/18	9/10/18	0.00	0.00	QC2 Machining-1		
130	QC	45 pcs	9/10/18	9/10/18	0.00	0.00	QC8 Machining-1		
140	Outsource	45 pcs	9/10/18	9/10/18			ATG001-VC		
150	Packaging	45 pcs	9/10/18	9/10/18	0.00	0.00	Packaging2		
155	QC	45 pcs	9/10/18	9/10/18	0.00	0.00	QC8		
180	Packaging	45 pcs	9/10/18	9/10/18	0.00	0.00	Packaging3-1		
190	QC21-SA	45 Ea	9/10/18	9/10/18	0.00	0.00	QC21		

Part Op 100 - Cut Blanks at 15.00"

Descriptions: 110 - 1-Machine per folio FB285 DWG REV: _____ FOLIO REV: _____ 2- deburr and break all sharp edges
140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 647.1900 2- PRIME AS PER DWG, SEE NOTE #2
Certification of Conformity is required
180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.1913E	Tee	56.2500 ft.(1.25 ea)	90-Start up Operation	91664

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	647.1913E	56	173	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Tee	0.630Inches $\pm$ 0.010	0.640 0.620	0.624"	
2	Tee	45.000degrees $\pm$ 0.500	45.500 44.500	45°	Angle
3	Tee	0.201Inches. + 0.005 - 0.001	0.206 0.200	0.202"	Diameter

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS					
				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
				Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
				Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
				Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:			QTY Effective :			MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

4	Tee	0.130Inches ± 0.010	0.140 0.120	0.132"
5	Tee	2.000Inches ± 0.010	2.010 1.990	1.999"
6	Tee	14.800Inches ± 0.010	14.810 14.790	14.808"
7	Tee	2.250Inches ± 0.002	2.252 2.248	2.250"
8	Tee	6.275Inches ± 0.005	6.280 6.270	6.275"
9	Tee	0.500Inches ± 0.005	0.505 0.495	0.497"
10	Tee	0.250Inches ± 0.010	0.260 0.240	0.250"
11	Tee	45.000degrees ± 0.500	45.500 44.500	45° Angle
12	Tee	1.250Inches ± 0.010	1.260 1.240	1.247"
13	Tee	0.130Inches ± 0.010	0.140 0.120	0.132"
14	Tee	0.100Inches ± 0.010	0.110 0.090	0.100" Radius
15	Tee	0.050Inches ± 0.010	0.060 0.040	0.050" Radius

JP
18-08-07

Plex 7/26/18 8:00 AM Dart.lajeunesse.marie



Container No: S100035



Part: 647.1913

Job No: 181389

Serial No/Batch: S100035

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/21/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Root Cause				FAULT CATEGORY																					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040777**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040777
PO Date: 8/20/18
Due Date: 9/7/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181419	647.7912	Clip ISSUE P/O: Hard Anodize, Color Black and Prime As Per Dwg. 647.7900	Firmed	-	9/7/18	100 pcs	0 pcs	100 pcs	\$9.35/pcs	\$935.00
							100 X	SEP 04 2018			
2	181352	647.1914	Bracket Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1900	Firmed	-	9/7/18	40 pcs	0 pcs	40 pcs	\$9.15/pcs	\$366.00
3	181391	647.1915	Support Angle Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1900 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed	-	9/7/18	30 pcs	0 pcs	30 pcs	\$11.45/pcs	\$343.50
							30 X	AUG 31 2018			
4	181389	647.1913	Tee Issue P/O to ATG : 1- Black Anodize as per Dwg 647.1900 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed	-	9/7/18	45 pcs	0 pcs	45 pcs	\$11.45/pcs	\$515.25
							45 X	SEP 10 2018		DAS 61 9-89	

CC

PURCHASE ORDER

Items												
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price	
5	178869	C10-1	Side Plate Solenoid Side -Issue P/O to ATG : -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/27/18	4 pcs	0 pcs	4 pcs	\$16.40/pcs	\$65.60	
4 X AUG 24 2018												
Line Item Note **big, big rush**												
6	178871	C10-2	Side Plate - MRK -Issue P/O to ATG: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	8/27/18	4 pcs	0 pcs	4 pcs	\$16.40/pcs	\$65.60	
4 X AUG 24 2018												
Line Item Note **Big, big rush**												
7	181358	647.1811	Spacer ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	-	9/7/18	50 pcs	0 pcs	50 pcs	\$6.90/pcs	\$345.00	
50 X AUG 31 2018												
Grand Total:											\$2,635.95	

Order Notes

Procurement Quality Clauses
 A005 right of entry
 A012 chemical and physical test report
 A016 personnel qualification
 A017 raw material identification (as applicable)

A022 Apical Processing
 A024 process certifications
 A026 certification of material conformance

A041 quality management system
 A042 dart notification by supplier
 A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915985

Date: 11-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
40 ea	Part: 647.1914 Bracket Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4 5mils). Job: 23616	Rev: N/C PO: PO040777 Line: 2	
45 ea	Part: 647.1913 Tee Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23618	Rev: NC PO: PO040777 Line: 4	DAS 61 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>11/9/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			